

Date: Thursday, 16/10/2008 10:07:03 AM
 -User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BO 105 SKIDTUBE ASSEMBLY
Job Number	: 42622		
Estimate Number	: 10112		
P.O. Number	:	Part Number	: D105674011G
This Issue	: 16/10/2008 S.O. No. :	Drawing Number	: D2966 REV A2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SKIDTUBES	Drawing Revision	: A2
Previous Run	: 42261	Material	:
Written By	:	Due Date	: 31/10/2008 Qty: 1 Um: Each
Checked & Approved By	JUD 08.10.16		
Comment	: Est Rev:A 04.07.07 New Issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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for JUD 09/10/05



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D105-674-011G CHG002

5 09/10/05

2.0	D2962125	Outer Tube Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2962-125 Extrusion *17532*

RT 08-10-16

3.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Determine square end of tube and deburr

2-Drill #30 pilot holes using DT8678. Open holes to Ø5/16" (0.313"). Deburr holes.

RT 08-10-16

4.0	BENDING	BENDING MACHINE - SKIDTUBES
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Comment: BENDING MACHINE

Bend tube as per program BO105 on CNC Bender and Dwg D2966. Use 5/16" locator pin on buggy "A".

RT 08-10-16

5.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut Fwd end of the tube using DT8185-1G

RT 08-10-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/10/2008 10:07:04 AM
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Drawing Name: BO 105 SKIDTUBE ASSEMBLY

Job Number: 42622

Part Number: D105674011G

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Cut Aft end at 107.06" using DT8185D

3-Deburr ends

4-Drill Aft Cap holes using DT8678

5-Locate DT8679 with 1/8 clecos in Aft Cap holes. Ensure DT8679 is centered on Fwd end of tube and drill #40 Fwd bushing.

6-Clamp DT8679 to the tube. Drill all #30 wearplate and crossbolt holes.

7-Open Aft Cap holes using #6 drill

8-Open wearplate holes and two side holes to Ø19/64" (0.297") as per Dwg D2966-1.

9-Deburr holes.

10-Open remaining (16) crossbolt holes to Ø0.500

BE
8-10-23

6.0

D2964

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2964

Cap

214101

A/R

Aluminum Rod

m109203

BE 8-10-23

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld Fwd Cap as per Dwg D2966 and QSI 004. Fill #40 Fwd cleco hole.

BE 8-10-23

2-Grind Fwd Cap welds flush

JB 8-10-27

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

8-10-27

W/O:		WORK ORDER CHANGES					
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9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

8086/7241

10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ARMY 8-12-11

11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DD

8-12-11

12.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Open crossbolt holes to finish size as per Dwg D2966

2-Open 14 holes to Ø0.750" & 2 holes to Ø0.875", countersink crossbolt holes & remove alodine to prepare for welding as per Dwg D2966

3-Deburr holes inside & outside, blow out chips

DD
pm 08-12-11

13.0	D2976	BO 105 Skidtube I Beam
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Numbe Description Batch

1 D2976 Web *472623*

pm 08-12-11 (C)

14.0	D2971	Cross Bolt Spacer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2971 Crossbolt Spacer

339001 *BE 08-12-15 +*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BO 105 SKIDTUBE ASSEMBLY

Job Number: 42622

Part Number: D105674011G

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

D2973

Cross Bolt Spacer



Comment: Qty.: 7.0000 Each(s)/Unit Total: 7.0000 Each(s)

Pick:

Qty Part Number Description Batch

7 D2973 Crossbolt Spacer

BE 08/12/15

16.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bond Web in place per QSI 015. (Ensure holes line up)

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291

m109883

Sikaflex expiry date :

09-07-11

*BE
Am' 08-12-11 (1)*

2-Weld Crossbolt Spacers as per Dwg D2966 and QSI 004. For crossbolt spacer, weld one side, pass 5/8" drill; weld other side, pass 5/8" drill.

Pick:

Qty Part Number Description Batch

A/R

Aluminum Rod

m109560 BE 08-12-15

3-Pass Ø0.630" drill to remove spillover for D2973 crossbolt. Pass Ø0.750" drill to remove spillover for D2971 crossbolt.

BE 08-12-15

4-Grind welds flush as per Dwg D2966

BE/Am' 08-12-15

17.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/12/15 (6)

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/15 (1)

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

BE 09-02-18 (1)

S.042 12.11

#1 323.6 F

#2 ---- F

#3 ---- F

#4 ---- F

*P 105674011G
1342622
19/02/2009*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: BO 105 SKIDTUBE ASS EMBLY

Job Number: 42622

Part Number: D105674011G

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FK 09/02/19 (1)

21.0

D2965

Cap, 105 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2965

Cap

B45884

UMD/FL

09/02/19

22.0

D29701

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2970-1

Wearplate

B43726

UMD/FL

09/02/19

23.0

D29703

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2970-3

Wearplate

B43727

UMD/FL

09/02/19

24.0

D31761

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3176-1

Bushing

B35627

UMD/FL

09/02/19

25.0

D31763

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3176-3

Nut

B37585

UMD/FL

09/02/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 42622

Part Number: D105674011G

Job Number:



Seq. #:	Machine Or Operation:	Description :
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26.0	ALS71032130	Insert
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Comment: Qty.: 36.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty Part Number Description Batch

36 ALS7-1032-130 Insert m108600

or ALS4-1032-130

or AKS7-1032-130

or AKS4-1032-130

ump / FL

09/02/19

27.0	AN960JD10L	Washer
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Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

Pick:

Qty Part Number Description Batch

28 AN960JD10L Washer m109632

ump / FL

09/02/19

28.0	MS27039108	Screw
------	------------	-------



Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)

Pick:

Qty Part Number Description Batch

26 MS27039-1-08 Screw m110467

ump / FL

09/02/19

29.0	MS27039109	Screw
------	------------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-1-09 Screw m18057

ump / FL

09/02/19

30.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1-Inspect for foreign objects as per QSI 024

2-Install Inserts, Wearplate and Cap per Dwg D2966. Insert a drop of sikaflex at insert holes before installing wearplates. Seal Aft Cap using Sikaflex. Install bushing and nut. By looking Fwd, install nut to right hand side.

Pick:

mp / FL

09/02/19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09/02/24	27.0	Add x2 washers AN960JD10L Batch: m109632	FL	09/02/24	2		S 09/02/24	
09/02/24	28.0	Add x2 screws MS270391-08 Batch: m110467	FL	09/02/24	2		S 09/02/24	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: BO 105 SKIDTUBE ASSEMBLY

Job Number: 42622

Part Number: D105674011G

Job Number:



Seq. #:

Machine Or Operation:

Description :

Qty Part Number Description Batch

A/R Sikaflex-291

Sikaflex expiry date:

M110110

09/07

WMD / FL

09/02/19 (X1)

3-Wing Walk as per Dwg D2966 and QSI 005 4.4

Batch:

M10454

- FL 09/02/24

(P)

31.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 09/02/24 (X1)

32.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*****ENSURE INSERT ARE AT LOCATION (6) AS PER DWG D2966*****

S 09/02/24 (X1)

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

34.0

D2972

Bushing



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

6 D2972

Bushing

33544

S 09/02/25 (X1)

35.0

D2974

Packer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2974

Packer

42715

S 09/02/25 (X1)

36.0

D2975

Wearshoe



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D2975

Wearshoe

B29538 x1 41443 x1

S 09/02/25 (X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 42622

Part Number: D105674011G

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0

AN451A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

3 AN4-51A Bolt

109285

SS 09/02/25 (X)

38.0

AN960JD10L

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN960JD10L Washer

M109632

SS 09/02/25 (X)

39.0

MS21042L4

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

3 MS21042L4

Nut

M109282

SS 09/02/25 (X)

40.0

MS27039108

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 MS27039-1-08 Screw

110552

SS 09/02/25 (X)

41.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 09/02/25 (X)

42.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D105-674-011G

Location: A

SS 09/02/25 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

43.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/05

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 09/02/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED #	APPROVED #	DRAWING NO. D2966	REV. A SHEET 1 OF 2
DATE 00.03.08		TITLE BO 105 SKIDTUBE ASSEMBLY	SCALE NTS
A	00.03.08	NEW ISSUE	

RELEASED
00.05.11 #

Qty	Part Number	Description
X	D2966-041	SKIDTUBE ASSEMBLY
1	D2962-125	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2970-1	WEARPLATE
1	D2970-3	WEARPLATE
1	D2971	CROSS BOLT SPACER
7	D2973	CROSS BOLT SPACER
1	D2976	WEB
36	ALS7-1032-130 or ALS4-1032-130 or AKS7-1032-130 or AKS4-1032-130	INSERT
28	AN960JD10L	WASHER
26	MS27039-1-08	SCREW
2	MS27039-1-09	SCREW
1	D3176-1	BUSHING
1	D3176-3	NUT

A2

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELDING TO BE DONE PER DART QSI 004.
- 3) INSERT D2976 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8451 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION B-B (34 PLACES) AFTER FINISH. SEAL WEARPLATE SCREWS WITH SIKAFLEX-241/-291.
- 5) DO NOT INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN THESE LOCATIONS.
- 6) INSTALL ALS7-1032-130 INSERT, MS27039-1-08 SCREW, AND AN960JD10L WASHER IN 2 PLACES THIS LOCATION BEFORE POWDER COATING.
- 7) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2976 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4 (OPTIONAL) BLACK SANDTEX (REF 4.3.5.7)

A1

01.01.24
CP 01.01.30

A2	02.10.30	ADD D3176-1/-3	# CP
A1	01.01.24	CHANGE COLOR TO BLACK SANDTEX	# CP

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42022

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

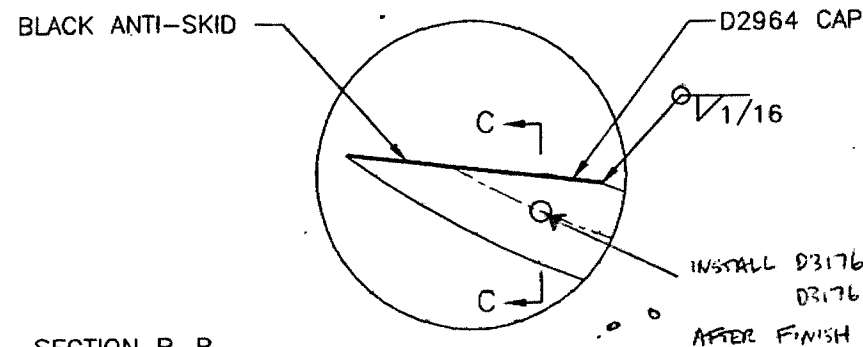
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

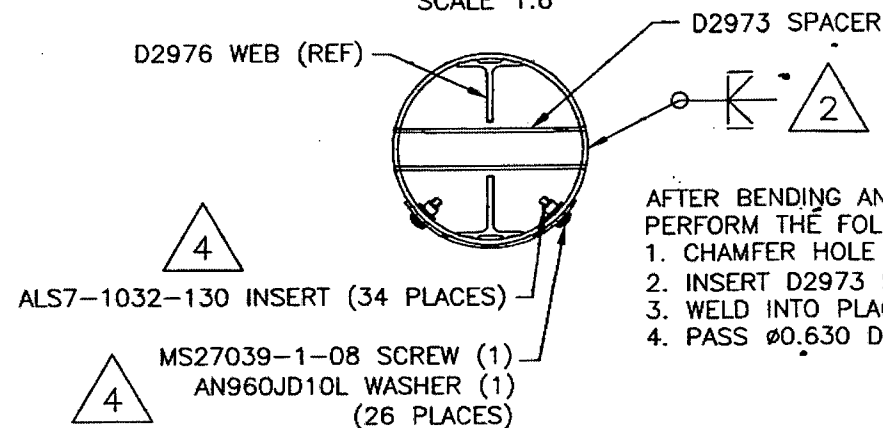
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DETAIL A
SCALE 1:3

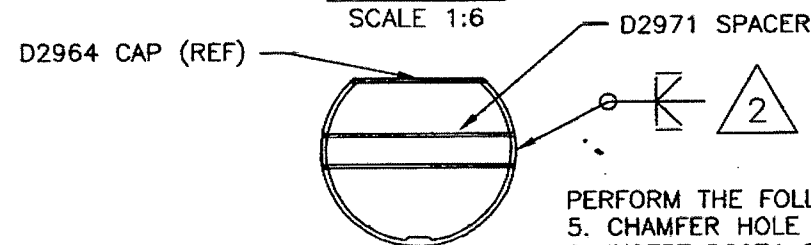


SECTION B-B
SCALE 1:6



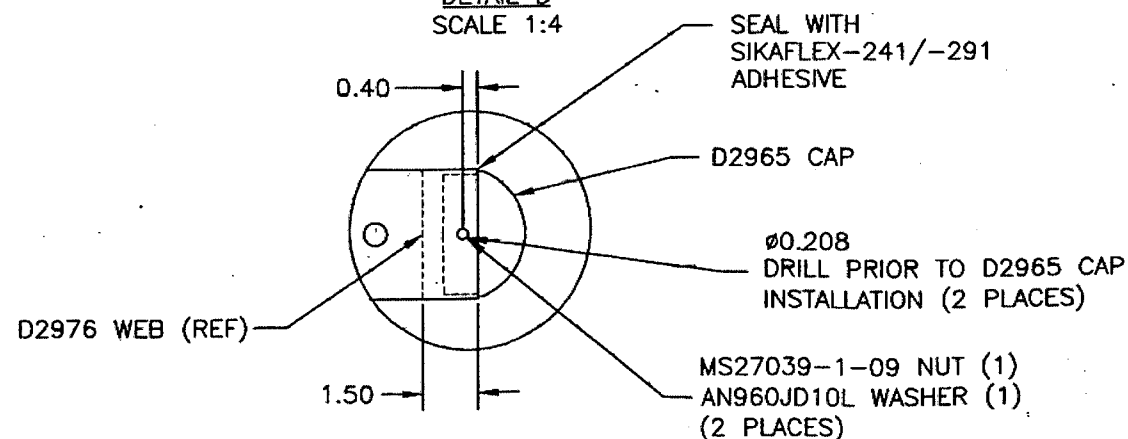
- AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.750 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D2973 SPACER (7 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. PASS 0.630 DRILL TO REMOVE SPILL OVER

SECTION C-C
SCALE 1:6

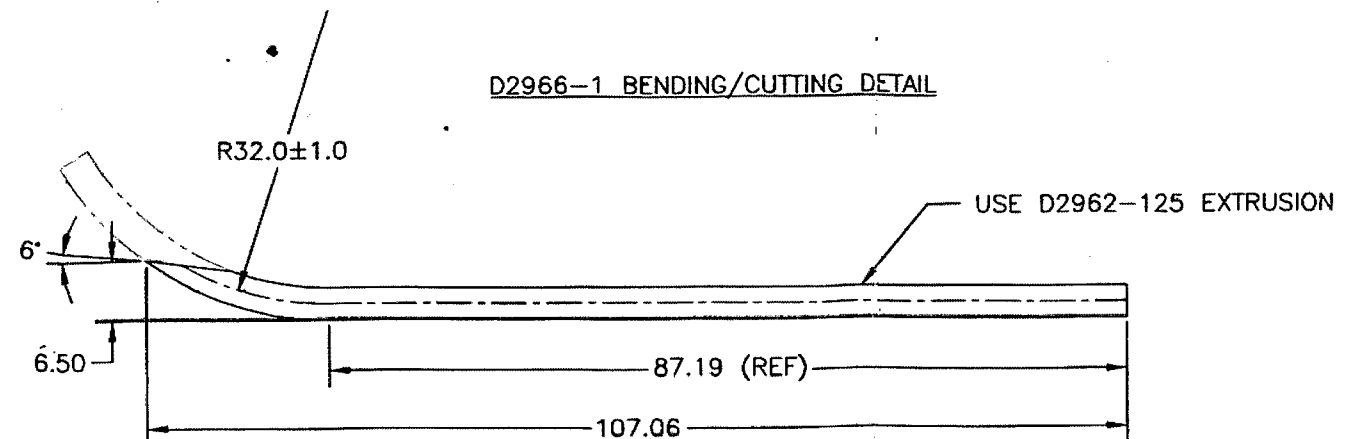


- PERFORM THE FOLLOWING FOR 0.625 HOLES ONLY:
5. CHAMFER HOLE 0.030 x 45°
 6. INSERT D2971 SPACER
 7. WELD INTO PLACE AND GRIND FLUSH
 8. PASS 0.484 DRILL TO REMOVE SPILL OVER

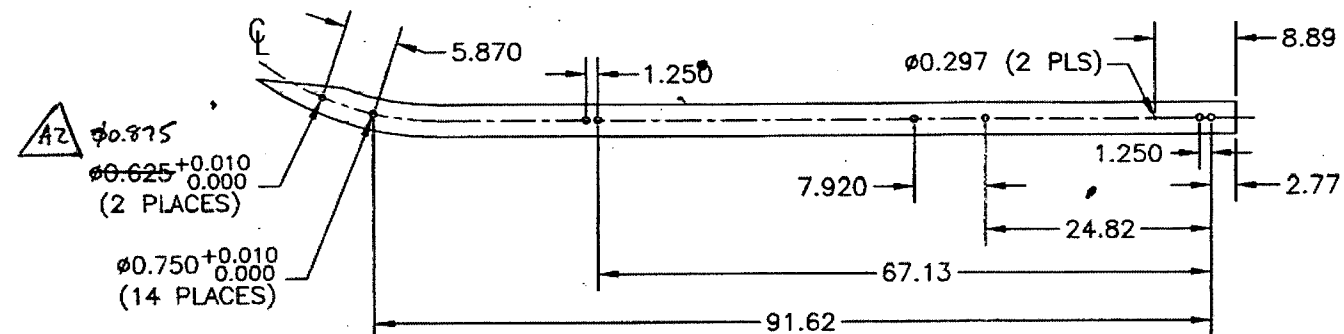
DETAIL D
SCALE 1:4



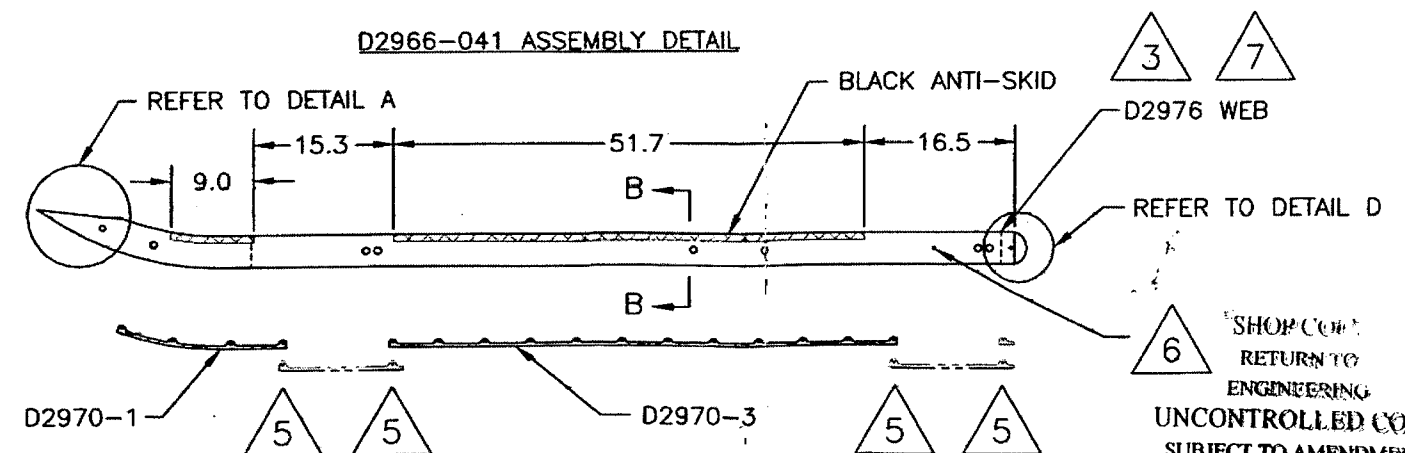
D2966-1 BENDING/CUTTING DETAIL



D2966-1 DRILLING DETAIL



D2966-041 ASSEMBLY DETAIL



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CHECKED
RF

DATE
00.03.08

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RF

APPROVED
RF

TITLE
BQ 105 SKIDTUBE ASSEMBLY

DART

DART AEROSPACE USA, INC.
BELLEVUE, WA

DRAWING NO.
D2966

SCALE
1:20

REV. A
SHEET 2 OF 2

NO. 172

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 41331
Part number: D105 674 011
Description: D105 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Ed Dwyer  Date of Test Coupon 08-09-05

Welder Barclay Elliot  Date of Test Coupon 08-09-05

The above named individual is qualified in accordance with AWS D17.1.2001 to weld